



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 198770



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Due Date: 8/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P
07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23
AS PER ECN11-684 VERF:EC IPP REV:S 17 12.08 REMOVE GASKET AS PER INTUITIVE INFO DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		8/30/19	0.00	0.65	Skidtubes - Bend		MBC
120	Skidtubes - 2 - B4B	1 pcs		8/30/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		TF
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		8/30/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S210805



Part: D205-634-041

Job No: 198770

Serial No/Batch: S210805

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3, FAA-STD SR005631

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

140 Skidtubes - 3 - B4B	1 pcs	8/30/19	0.00 3.00	Skidtubes - 1 - B4B	TF
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 10	1 pcs	8/30/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	DAS
				QC 10 - 43	24
				QC 10 - 50	9-89
				QC 10 - 58	
				QC 10 - 9	
160 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	8/30/19	0.00 1.31	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 -	

				B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
180 Powdercoat - 1 White GI(A)- B4B	1 pcs	8/30/19	0.00 0.34	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
190 QC 3	1 pcs	8/30/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
200 Handfinish - 4-1-Assembly- B4B	1 pcs	8/30/19	0.00 1.00	Handfinish - 4 - 1 - B4B		
				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		
				Handfinish - 4 - 2 - B4B		
				Handfinish - 4 - 3 - B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
210 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		

					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	SEP 2 5 2019
					QC 5 - 61	
					QC 5 - 81	
220	Packaging 3-1 - Stock - B4B	1 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	SEP 2 6 2019
					Packaging 3 - 36 - B4B	
225	DC - 1 - B4B	1 pcs	8/30/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
230	QC 21 - FG	1 pcs	8/30/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

DAG
40
9-89MAD
B9/26/
2019DAG
21
9-89

SEP 2 6 2

DAG
21
9-89

SEP 2 6 2019

Part Op 110 - Skidtubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe
Descriptions: batch# in aft end of tube

120 - Skidtubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skidtubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert
D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube

A/R
139011

expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Debur 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 5200625 Sikaflex expire date: 20/07 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 5200625 Sikaflex expire date: 20/07 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 5207362

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - Bend - 1	<u>5200301</u>
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	<u>5177095</u>
D4202-1	Spacer	20 pcs (20 ea)	140-Skidtubes - 3 - B4B	<u>5184087</u>
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5190021</u>
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5149158</u>
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5209067</u>
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>8x5196678/11x5206811</u>
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>3x5123217/5045927v13</u>
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5194824</u>
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5201764</u>
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5186227</u>
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5201529</u>
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5201653</u>
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5193136</u>
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	<u>5178378</u>

M.H. 012132 3x206804

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	4	0
140-Skidtubes - 3 - B4B	D2576-3	1	78	0
	D4202-1	20	861	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,256	0
	AN3-5A	2	84	0
	AN3C4A	50	1,293	0
	D2594-1	16	170	0
	D2594-3	16	195	0
	D2855	1	93	0
	D3564-11	1	27	0
	D3564-13	1	16	0
	D3564-5	1	16	0
	D3564-9	1	18	0
	NAS1149C0332R	50	3,456	0
	NAS1149D0332J	2	2,549	0

Part Specifications

Specifications could not be found.

ITEM	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X	-041	-047	-048	D2680-041	SKIDTUBE ASSEMBLY
2					D2680-048	SKIDTUBE ASSEMBLY
3					D2680-047	SKIDTUBE ASSEMBLY
4				X	D2680-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2680-1-180	EXTRUSION
21			10	18	D2670	PUSHING
22	1	1	1	1	D2678-3	STEP
23			4		D2678	SPACER
24	18	18	8	8	D2684-1	PLUG
25	18	18	8	8	D2684-3	O-RING
26	1	1	1	1	D2686	200 WEB
27	1	1	1	1	D2685	AFT CAP
28	1	1	1	1	D2684-3	WEARSHOE
29	1	1	1	1	D2684-9	WEARSHOE
30	1	1	1	1	D2684-11	WEARSHOE
31	1	1	1	1	D2684-13	WEARSHOE
32	20	20	24	24	D4002-1	SPACER
33			1		D4008-041	WEARPLATE ASSEMBLY
34			1		D4008-048	WEARPLATE ASSEMBLY
35				1	D2681-1	PHD WEARPLATE
36				1	D2681-3	AFT WEARPLATE
50	50	50			AL57-1002-130 or AK57-1002-130 or AK54-1002-130 or AL5-1002-130	INSERT
51	50	50			AK54A	BOLT
52	2	2	2	2	AK54A	BOLT
53			8	8	AK54A	BOLT
54	50	50			NA51140C032R	WASHER (AN60010L)
55	2	2	2	2	NA51140C032J	WASHER (AN60010L)
56			8	8	NA51140-4	NUT (OR M52104R-4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART Q81 005 4.1 PRIOR TO INSERTING D2680 WEB POWDER COAT (441-1047-1048) GLOSS WHITE (REF 4.3.4.1) PER DART Q81 005 4.3 BLACK ANTI-WEAR PAINT AS NOTATED PER DART Q81 005 4.4.
- 3) TOLERANCES ARE PER DART Q81 018 UNLESS OTHERWISE NOTED.
- 4) LIMITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2680-041 = 33.7 lbs
D2680-045 = 33.7 lbs
D2680-047 = 45.1 lbs
D2680-048 = 32.0 lbs
- 8) WELDING PER DART Q81 004.
- 9) INSERT D2680 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART Q81 015 BEFORE BONDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 90 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE D78217 & D78257 ONLY FOR D2680-041-048 TO LOCATE AND DRILL 0A-207 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1002-130 PER SECTIONS B-B AND F-F (60 PLACES) AFTER FINISH. INSTALL AK54A BOLTS AND NA51140C032R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2684-1 PLUG C/W D2684-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES FOR D2680-041-048 AND 8 PLACES FOR D2680-047-049).
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2686 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

REV.	DESCRIPTION	BY	DATE
H	SHEET: PL DELETE D2680-1A-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048 -047 WEIGHT UPDATED PER D81 8008	AJS	14.04.09
F	INCORPORATE DED D2680-E-1 PER PART-218	DC	13.06.20
E	ADD D2680-047 (2N C-47) AND D2680-7 (2N B-47) INCLUDED DED D2680-D-1; REFORMATTED DRAWING TO CURRENT STANDARD; D78217 & D78257 WAS TO2677-255 (2N C-41)	RF	11.06.21
D	CHANGE TO 50 WEARPLATES AND GASKETS, INCLUDE DED D724 018	PH	07.04.06
C	REDRAWN, INCLUDED DED 9094 0097	CP	06.06.20
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
DESIGN	D6	DATE	
DRAWN	SAD		
CHECKED	13		
INFO. APPR.	D2680		
APPROVED	#		
DE APPR.	#		
DATE	17.06.09		

DART AEROSPACE LTD
HARRISBURG, ONTARIO, CANADA

DRAWING NO. D2680
SHEET 1 OF 6

REV. H
SCALE
NTB

COMPONENT 6 1008 187 DART AEROSPACE LTD
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19-08-06

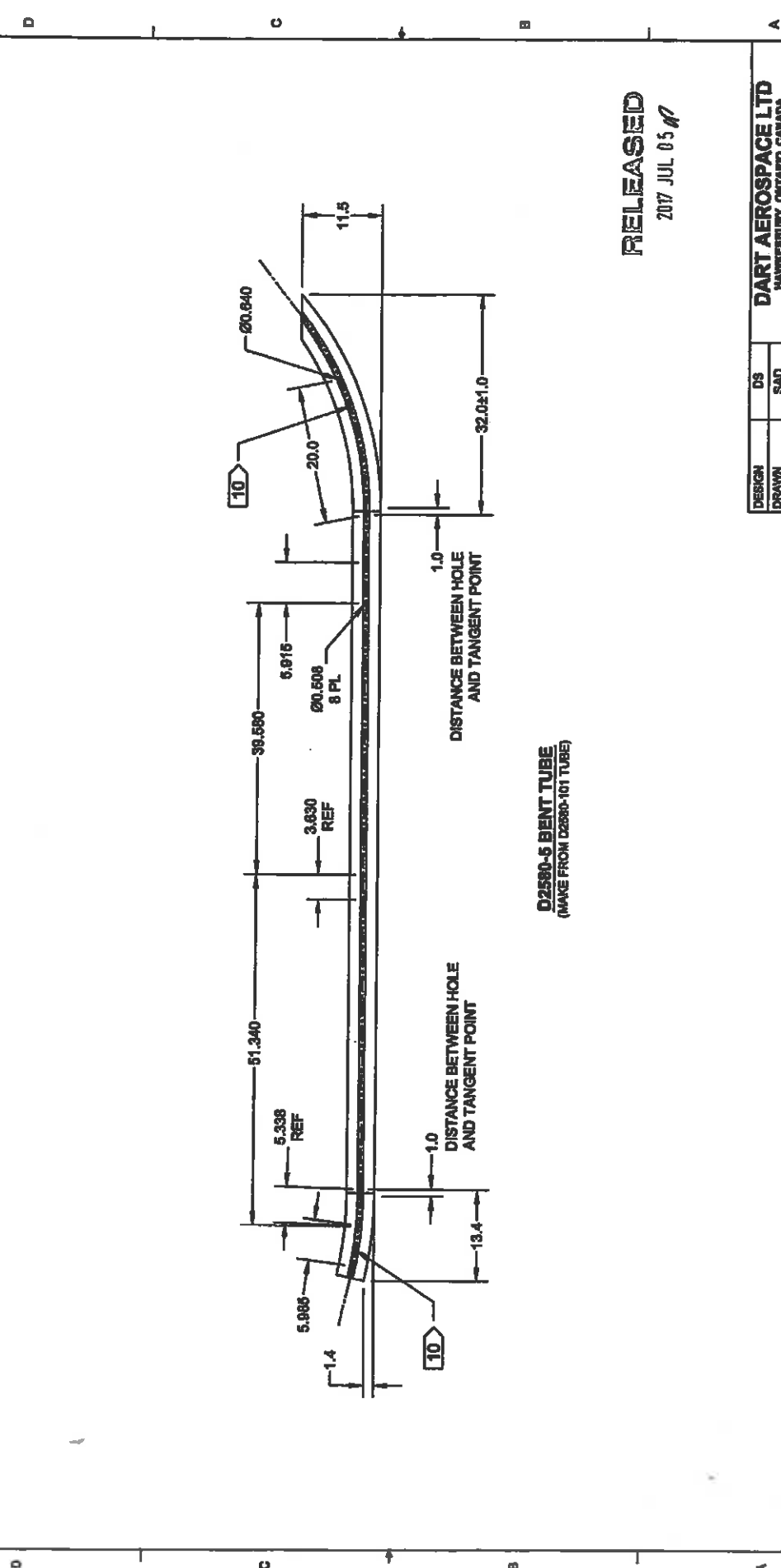
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2017 JUL 05 4
5047-541



RELEASED
2017 JUL 05 4

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2680 REV. H SHEET 3 OF 6 SCALE NTS TITLE 206 SKIDTUBE ASSEMBLY NTS COPYRIGHT © 1988 BY DART AEROSPACE LTD THIS DRAWING IS UNCLASSIFIED AND IS TO BE RELEASED TO THE PUBLIC ON REQUEST. DISSEMINATION OF THIS DRAWING IS UNRESTRICTED.	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DATE	17.06.09	DE APPR.	<i>[Signature]</i>

1 2 3 4 5 6 7 8



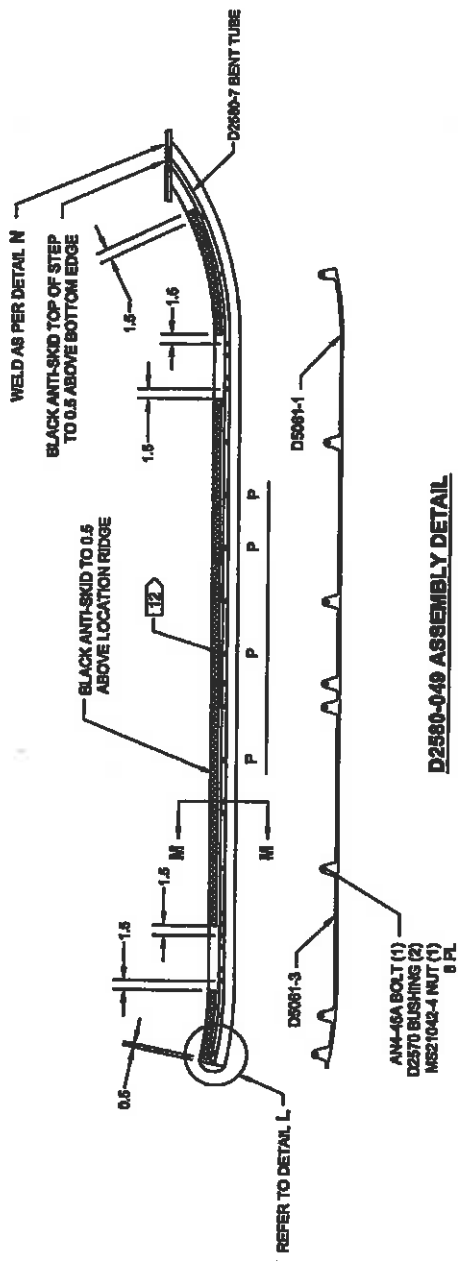
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
2017 JUL 05

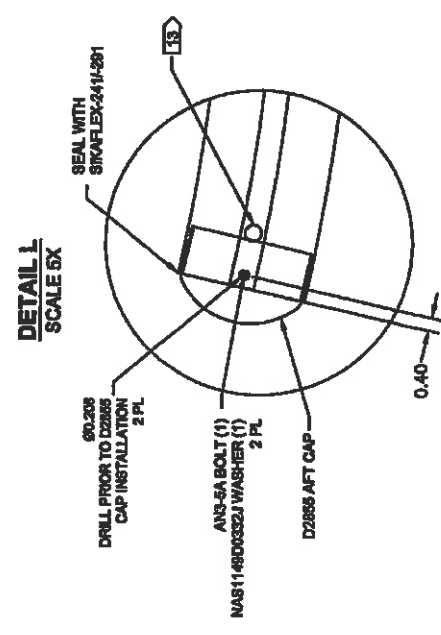
DESIGN	DS	SAD	DART AEROSPACE LTD	
DRAWN			HARRISBURG, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. H
IMP. APPR.			D2580	SHEET 6 OF 9
APPROVED			TITLE	SCALE
DATE	17.06.09		208 SKIDTUBE ASSEMBLY	NTS

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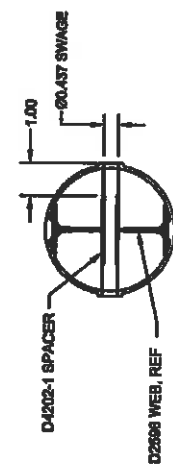
1 2 3 4 5 6 7 8



D2590-049 ASSEMBLY DETAIL

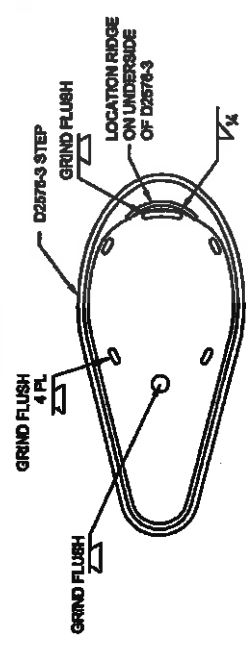


SECTION M-M SCALE 5X



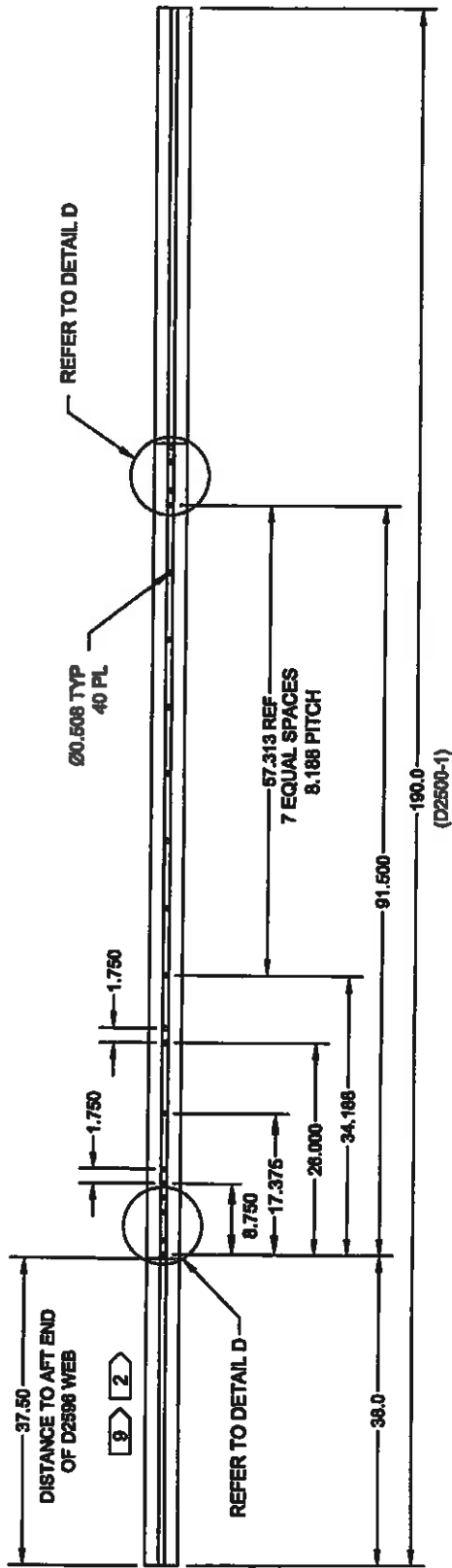
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR 90.437 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO 90.437 X 1.00 DEEP PER QSI 002.
3. THINGRIND FLUSH PER QSI 002

DETAIL N SCALE 5X

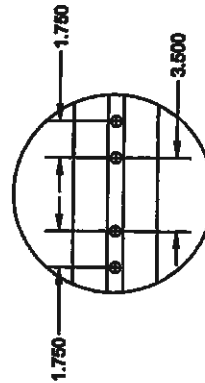


DESIGN	DS	SAD	DART AEROSPACE LTD
DRAWN	CHECKED	INFO. APPL.	HAYRESBURY, ONTARIO, CANADA
APPROVED	DATE	DRAWING NO.	REV. H
	17.06.09	D2590	SHEET 7 OF 9
		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	NTS
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2017 JUL 05



D2580-101 TUBE



DETAIL D
SCALE 6X

DESIGN	DB	DART AEROSPACE LTD
DRAWN	SAD	HAWTHORNE, ONTARIO, CANADA
CHECKED	REV. H	
MFG. APPR	DRAWING NO.	D2580
APPROVED	TITLE	206 SKIDTUBE ASSEMBLY
DATE	17.06.09	NTS

RELEASED
2017 JUL 05

CONFIDENTIAL
NOT FOR RELEASE
EXCEPT BY AUTHORITY OF
THE CANADIAN GOVERNMENT



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS					
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	MRB (Q51042)	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (Q51042)			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY					
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		
		Other/Details: _____					
Completed By		Lead hand / Supervisor		QC / QA Coordinator			